

Tapping Systems – ANSI Tap Collets



MicroFLOAT

Rigid Tapping Holders

Increase Tap Life 295%



Tension-Compression Tap Holders

Automatically compensate for machine feed rates to improve results.



Rigid Tap Chucks

Easy to use and reliable tap holders for general tapping applications.



ANSI Clutch Drive & Rigid Tap Collets

Clutch drive automatically stops spinning if tap reaches bottom of hole preventing broken taps.



<http://ow.ly/rli2o>

View the MicroFLOAT Tapping video.



Built for Speed.

All Techniks products are backed by our 100% satisfaction guarantee!



Synchronous Feed Holders for Rigid Tap Cycles



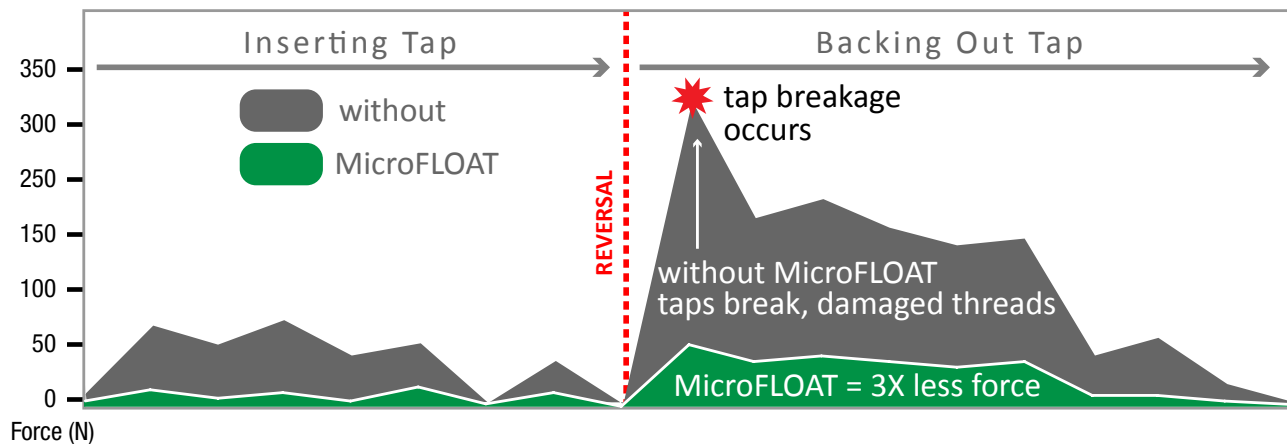
MicroFLOAT Tap Holders

- *prevent broken taps*
- *increase tap life 295%*
- *improve thread quality*



Stop breaking so many taps

This graph shows how MicroFLOAT reduces stress on the tap during tapping cycle.



Synchronous feed eases the tap through the whole cycle, preventing breakage.

Synchronous Feed Holders for Rigid Tap Cycles

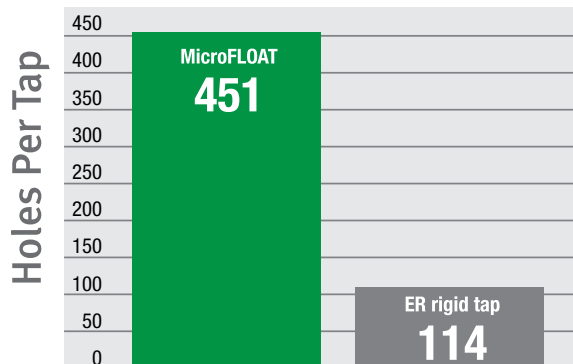
MicroFLOAT improves CNC Rigid Tapping

No matter how good your machine's tapping cycle is, there are always small mechanical variances that produce path inaccuracies during tapping. These variances cause wear on the tap, leading to premature tap failure and poor thread quality.

MicroFLOAT synchronous feed holders cushion the sudden shocks taps are subject to, minimizing damage to the tap. MicroFLOAT's ability to compensate for feed variances provides unmatched stability.

MicroFLOAT is the recommended solution for improving rigid tapping performance and extending tap life.

MicroFLOAT Test: 295% more holes per tap! You can expect similar results



Machine: Mori Seiki SH403
Material: AISI 304
Coolant: 7% concentration
Cutting speed: 12m/min
Thread: M6; 12 mm depth
Tap: UFS, K82M6X-TXC

On a machining center we compared an ER rigid tap holder to a MicroFLOAT holder. The only difference was the tool holder. As you can see, the savings are significant. MicroFLOAT yields 337 more threaded holes per tap!

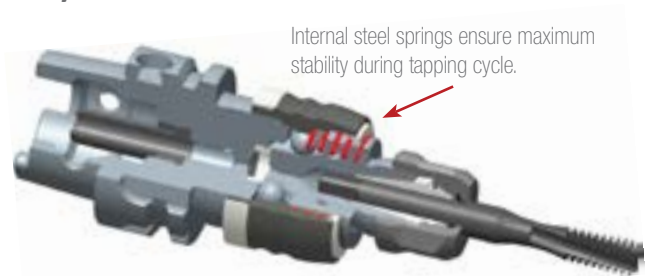
See MicroFLOAT in action...



<http://bit.ly/29e85vZ>

Key Technology Features

1. Synchronous Feed – In and Out



During the tapping cycle MicroFLOAT's synchronous feed technology automatically corrects for mechanical variances such as ballscrew play, spindle wear, or material irregularities to produce the truest possible threads. Internal steel spring compensation allows 0.008" (.2mm) of compression and 0.040" (1mm) of tension, effectively compensating for path inaccuracies and protecting the tap from metal fatigue and breaking. Because the tap follows the exact same path both in and out of the hole, optimum thread quality is achieved.

2. Quick-change Tap Adapters

Adapters make tap changes fast and easy. Change taps in spindle without presetting equipment.



3. Modular extensions achieve lengths up to 9"

Quickly combine adapters and extensions to create lengths up to 9 inches without sacrificing accuracy.



4. Coolant-thru technology

High-pressure (50 Bar) coolant through is standard.



How to Order – MicroFLOAT Synchronous Feed Holders

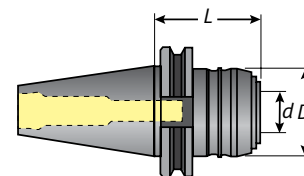
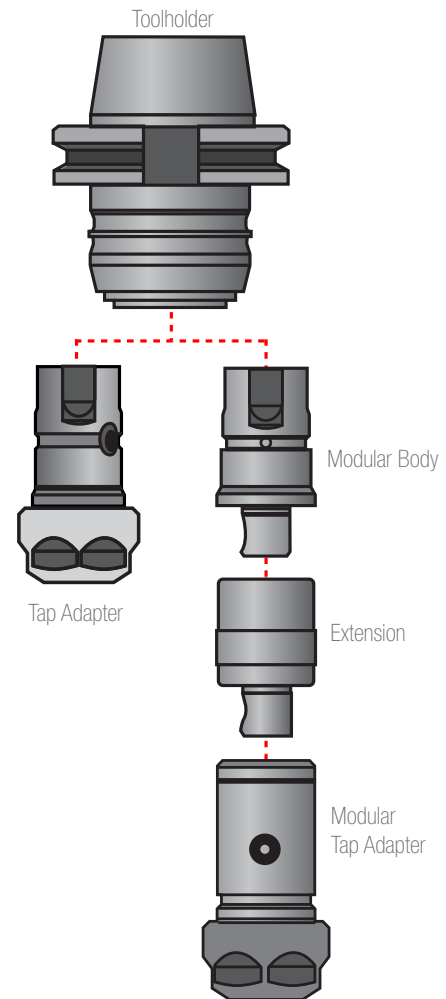
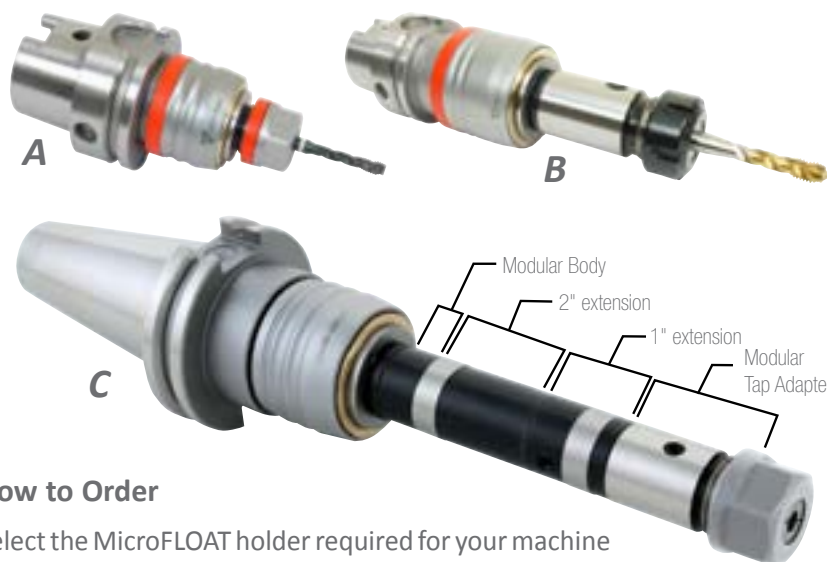
MicroFLOAT Components

MicroFLOAT is an easy to use system that can be expanded to achieve lengths of 9" using extensions. Quick-change connection makes tap replacement fast and easy even in-spindle.

Refer to the diagram (right) to identify system components.

MicroFLOAT tap holders can be configured three ways:

- A using a holder with a quick-change tap adapter
- B holder with a modular body and modular tap adapter
- C holder with a modular body, extensions, and tap adapter



How to Order

Select the MicroFLOAT holder required for your machine spindle and tap size from the table (right).

NOTE: #1 holders fit our #1 ER16 tap adapters, which can hold tap sizes up to 3/8".

NOTE: #2 holders fit our #2 ER25 tap adapters, which can hold tap sizes up to 11/16".

For configuration **A**, (using a holder with a quick-change tap adapter) select the correct quick-change tap adapter from the table below.

For configurations **B** or **C**, select a modular body, extensions if needed, (1" or 2" available) and modular quick-change tap adapter from the tables on the next page.

Quick-Change Tap Adapter (use for configuration A)

ER16 fits taps up to 3/8"
ER25 fits taps up to 11/16"



Part No.	Description	L	D	d
23410-ER16	ER16 tap adapter #1	2.16"	1.10"	.79"
23610-ER25	ER25 tap adapter #2	3.39"	1.65"	1.27"

MicroFLOAT Toolholders

#1 holders fit #1 ER16 tap adapters and #1 components.

#2 holders fit #2 ER25 tap adapters and #2 components.

Part No.	Description	L	D	d
23400-40CAT	CAT40 holder #1	2.75"	1.7"	0.79"
23600-40CAT	CAT40 holder #2	3.54"	2.36"	1.26"
23400-50CAT	CAT50 holder #1	2.75"	1.7"	0.79"
23600-50CAT	CAT50 holder #2	3.54"	2.36"	1.26"
23400-30BT	BT30 holder #1	2.09"	1.7"	0.79"
23400-40BT	BT40 holder #1	2.40"	1.7"	1.26"
23600-40BT	BT40 holder #2	3.22"	2.36"	1.26"
23400-H63A	HSK63A holder #1	2.52"	1.7"	.79"
23400-INC1	1" Straight Shank holder # 1	1.3"	1.7"	0.79"
23600-INC1	1" Straight Shank holder # 2	2.13"	2.36"	1.26"

MicroFLOAT Components and ER Rigid Tap Collets



Modular components are sized #1 and #2

#1 holders fit #1 modular components

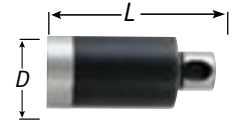
#2 holders fit #2 modular components



Modular Body

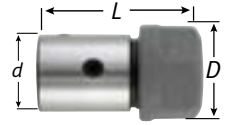
Part No.	Description	L	D	d
23411-MOD	Modular Body MicroFLOAT #1	.20"	.91"	.79"
23611-MOD	Modular Body MicroFLOAT #2	.28"	1.38"	1.26"

Modular Extensions



Part No.	Description	L	D	Chuck
42150-25	1" Mod. Extension #1	.98"	.91"	23400-..
42150-50	2" Mod. Extension #1	1.97"	.91"	23400-..
42250-50	2" Mod. Extension #2	1.97"	1.38"	23600-..
42250-100	4" Mod. Extension #2	3.94"	1.38"	23600-..

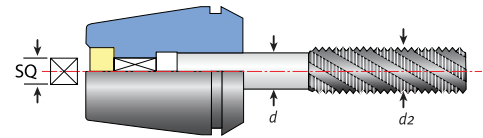
ER Modular Tap Adapters



Part No.	Description	L	D	d
42147-ER16	ER16 Mod. Adapter #1	1.97"	1.10"	.91"
42247-ER25	ER25 Mod. Adapter #2	3.11"	1.65"	1.38"



- Square drive prevents spinning the tap
- High-carbon steel, heat treated for long life
- Precision ground and polished



ER16, ER25 Rigid Tap Collets (inch)

Part No.	Size	d	SQ	Tap Size (d2)
05320-141	ER16	.141"	.110"	1/8" or #6
05320-168	ER16	.168"	.131"	5/32" or #8
05320-194	ER16	.194"	.152"	3/16" or #10
05320-220	ER16	.220"	.165"	7/32" or #12
05320-255	ER16	.255"	.191"	1/4"
05320-318	ER16	.318"	.238"	5/16"
05320-323	ER16	.323"	.242"	7/16"
05320-367	ER16	.367"	.275"	1/2"
05320-381	ER16	.381"	.286"	3/8"
05510-141	ER25	.141"	.110"	1/8" or #6
05510-168	ER25	.168"	.131"	5/32" or #8
05510-194	ER25	.194"	.152"	3/16" or #10
05510-220	ER25	.220"	.165"	7/32" or #12
05510-255	ER25	.255"	.191"	1/4"
05510-318	ER25	.318"	.238"	5/16"
05510-323	ER25	.323"	.242"	7/16"
05510-367	ER25	.367"	.275"	1/2"
05510-381	ER25	.381"	.286"	3/8"
05510-429	ER25	.429"	.322"	9/16"
05510-437	ER25	.437"	.328"	1/8" NPT
05510-480	ER25	.480"	.360"	5/8"
05510-542	ER25	.542"	.406"	11/16"

ER16, ER25 Rigid Tap Collets (metric)

Part No.	Size	d	SQ	Tap Size (d2)
05326-DIN	ER16	2.8	2.1	M4
05330-DIN	ER16	3.5	2.7	M3
05336-DIN	ER16	4.5	3.4	M4
05342-DIN	ER16	6	4.9	M5/M6
05350-DIN	ER16	8	6.2	M8
05352	ER16	8.5	6.5	M12
05354-DIN	ER16	9	7	M12
05356-DIN	ER16	10	8	M10
05371	ER16	6	4.5	M6
05385	ER16	6.2	5	M8
05526-DIN	ER25	4.5	3.4	M4
05534-DIN	ER25	6	4.9	M5/M6
05540-DIN	ER25	7	5.5	M10
05542-DIN	ER25	8	6.2	M8
05548-DIN	ER25	9	7	M12
05550	ER25	10	8	M10
05550-DIN	ER25	10	8	M10
05554-DIN	ER25	11	9	M14
05558-DIN	ER25	12	9	M16



We stand behind all our CNC tooling solutions from spindle to workpiece.

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CAT, BT Tension / Compression Tap Holders



Techniks Quality Features

- Adjustable compression helps start difficult taps
- Taper ground to AT3 accuracy or better
- Quick-Change Style



ANSI Tap
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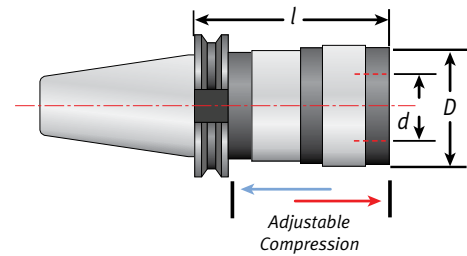
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CAT Tension / Compression Tap Holders

Part No.	Description	d	D	l	Size	Tap	Compensation	
						Capacity	Tension	Compression
32400/40CAT	CAT40 T/C Holder, Size 1	0.748"	1.5"	2.36"	1	0 – 9/16"	0.35"	0.35"
32400/50CAT	CAT50 T/C Holder, Size 1	0.748"	1.5"	2.44"	1	0 – 9/16"	0.35"	0.35"
32600/40CAT	CAT40 T/C Holder, Size 2	1.220"	2.17"	3.94"	2	5/16 – 7/8"	0.59"	0.59"
32600/50CAT	CAT50 T/C Holder, Size 2	1.220"	2.17"	3.27"	2	5/16 – 7/8"	0.59"	0.59"
32800/40CAT	CAT40 T/C Holder, Size 3	1.890"	3.11"	5.43"	3	1/2 – 1-3/8"	0.94"	0.94"
32800/50CAT	CAT50 T/C Holder, Size 3	1.890"	3.11"	5.24"	3	1/2 – 1 3/8"	0.94"	0.94"
32900/40CAT	CAT40 T/C Holder, Size 4	2.362"	3.86"	6.06"	4	1-7/16 – 1-7/8"	1.02"	1.02"
32900/50CAT	CAT50 T/C Holder, Size 4	2.362"	3.86"	5.79"	4	1-7/16 – 1-7/8"	1.02"	1.02"

BT Tension / Compression Tap Holders

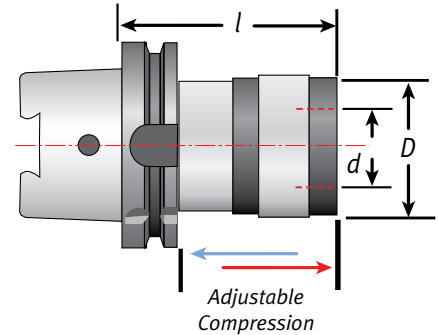
Part No.	Description	d	D	l	Size	Tap	Compensation	
						Capacity	Tension	Compression
32400/30BT	BT30 T/C Holder, Size 1	0.748"	1.5"	2.48"	1	0 – 9/16"	0.35"	0.35"
32400/40BT	BT40 T/C Holder, Size 1	0.748"	1.5"	2.68"	1	0 – 9/16"	0.35"	0.35"
32400/50BT	BT50 T/C Holder, Size 1	0.748"	1.5"	3.15"	1	0 – 9/16"	0.35"	0.35"
32600/30BT	BT30 T/C Holder, Size 2	1.220"	2.17"	3.78"	2	5/16 – 7/8"	0.59"	0.59"
32600/40BT	BT40 T/C Holder, Size 2	1.220"	2.17"	3.66"	2	5/16 – 7/8"	0.59"	0.59"
32600/50BT	BT50 T/C Holder, Size 2	1.220"	2.17"	4.02"	2	5/16 – 7/8"	0.59"	0.59"
32800/40BT	BT40 T/C Holder, Size 3	1.890"	3.11"	5.43"	3	1/2 – 1-3/8"	0.94"	0.94"
32800/50BT	BT50 T/C Holder, Size 3	1.890"	3.11"	5.31"	3	1/2 – 1-3/8"	0.94"	0.94"
32900/40BT	BT40 T/C Holder, Size 4	2.362"	3.86"	6.18"	4	1-7/16 – 1-7/8"	1.02"	1.02"
32900/50BT	BT50 T/C Holder, Size 4	2.362"	3.86"	5.79"	4	1-7/16 – 1-7/8"	1.02"	1.02"

HSK & Straight Shank Tension / Compression Tap Holders



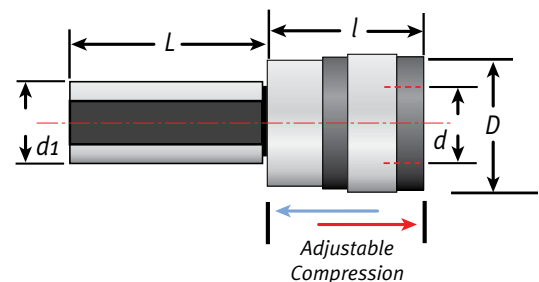
Techniks Quality Features

- Adjustable compression helps start difficult taps
- Quick-Change Style



HSK A Tension / Compression Tap Holders

Part No.	Description	d	D	l	Size	Tap Capacity	Compensation	
							Tension	Compression
34400/H40A	HSK40A T/C Holder, Size 1	0.748"	1.5"	3.14"	1	0 – 9/16"	0.295"	0.295"
34400/H50A	HSK50A T/C Holder, Size 1	0.748"	1.5"	2.83"	1	0 – 9/16"	0.295"	0.295"
34400/H63A	HSK63A T/C Holder, Size 1	0.748"	1.5"	2.83"	1	0 – 9/16"	0.295"	0.295"
34400/H100A	HSK100A T/C Holder, Size 1	0.748"	1.5"	3.14"	1	0 – 9/16"	0.295"	0.295"
34600/H50A	HSK50A T/C Holder, Size 2	1.22"	2.17"	4.33"	2	5/16 – 7/8"	0.393"	0.393"
34600/H63A	HSK63A T/C Holder, Size 2	1.22"	2.17"	4.33"	2	5/16 – 7/8"	0.393"	0.393"
34600/H100A	HSK100A T/C Holder, Size 2	1.22"	2.17"	3.94"	2	5/16 – 7/8"	0.393"	0.393"



Straight Shank Tapping Chucks

Part No.	Description	D1	D	l	L	Tap Capacity	Compensation	
							Tension	Compression
32400/INC1	1" shank T/C Holder, Size 1	1.00"	1.5"	1.76"	1.95"	0 – 9/16"	0.35"	0.35"
32600/INC1	1" shank T/C Holder, Size 2	1.00"	2.17"	2.52"	2.00"	5/16 – 7/8"	0.59"	0.59"
32600/INC1-1/2	1 1/2" shank T/C Holder, Size 2	1.50"	2.17"	2.52"	3.50"	5/16 – 7/8"	0.59"	0.59"
32800/INC1-1/2	1 1/2" shank T/C Holder, Size 3	1.50"	3.38"	3.85"	3.50"	1/2 – 1 3/8"	0.94"	0.94"



CAT, BT Rigid Tap Holders



Techniks Quality Features

- Taper ground to AT3 accuracy or better
- Quick-Change Style



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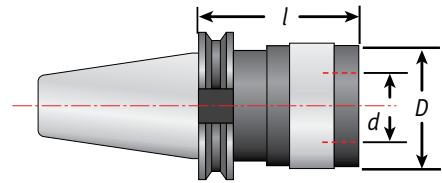
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CAT Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/40CAT	CAT40 Rigid Tap Holder, Size 1	2.59"	1.31"	0.748"	1	0 – 9/16"
21480/50CAT	CAT50 Rigid Tap Holder, Size 1	2.95"	1.31"	0.748"	1	0 – 9/16"
21680/40CAT	CAT40 Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 – 7/8"
21680/50CAT	CAT50 Rigid Tap Holder, Size 2	3.86"	1.97"	1.22"	2	5/16 – 7/8"
21880/40CAT	CAT40 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 – 1 3/8"
21880/50CAT	CAT50 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 – 1 3/8"

BT Rigid Tap Holders

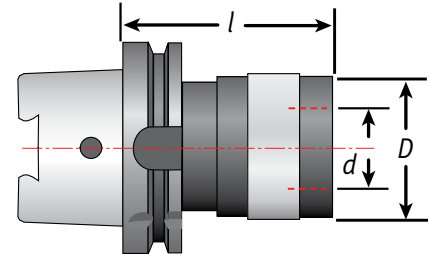
Part No.	Description	l	D	d	Size	Tap Capacity
21480/30BT	BT30 Rigid Tap Holder, Size 1	2.80"	1.31"	0.748"	1	0 - 9/16"
21480/40BT	BT40 Rigid Tap Holder, Size 1	2.63"	1.31"	0.748"	1	0 - 9/16"
21480/50BT	BT50 Rigid Tap Holder, Size 1	3.07"	1.31"	0.748"	1	0 - 9/16"
21680/30BT	BT30 Rigid Tap Holder, Size 2	3.70"	1.97"	1.22"	2	5/16 - 7/8"
21680/40BT	BT40 Rigid Tap Holder, Size 2	3.54"	1.97"	1.22"	2	5/16 - 7/8"
21680/50BT	BT50 Rigid Tap Holder, Size 2	3.97"	1.97"	1.22"	2	5/16 - 7/8"
21880/40BT	BT40 Rigid Tap Holder, Size 3	4.61"	2.83"	1.89"	3	1/2 - 1 3/8"
21880/50BT	BT50 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"

HSK and Straight Shank Rigid Tap Holders



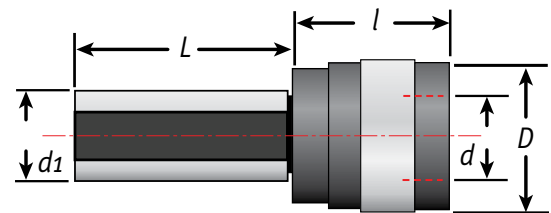
Techniks Quality Features

- Quick-Change Style



HSK Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/H50A	HSK50A Rigid Tap Holder, Size 1	2.30"	1.31"	0.748"	1	0 - 9/16"
21480/H63A	HSK63A Rigid Tap Holder, Size 1	2.32"	1.31"	0.748"	1	0 - 9/16"
21480/H100A	HSK100A Rigid Tap Holder, Size 1	2.95"	1.31"	0.748"	1	0 - 9/16"
21680/H50A	HSK50A Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 - 7/8"
21680/H63A	HSK63A Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 - 7/8"
21680/H100A	HSK100A Rigid Tap Holder, Size 2	3.86"	1.97"	1.22"	2	5/16 - 7/8"
21880/H63A	HSK63A Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"
21880/H100A	HSK100A Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"



Straight Shank Rigid Tap Holders

Part No.	Description	d1	L	l	D	d	Tap Capacity
21480/INC1	1" shank, Rigid Tap Holder, Size 1	1.00"	1.95"	1.60"	1.31"	.748"	0 - 9/16"
21680/INC1	1" shank, Rigid Tap Holder, Size 2	1.00"	2.00"	2.50"	1.97"	1.22"	3/8 - 7/8"
21880/INC1-1/2	1 1/2" shank, Rigid Tap Holder, Size 3	1.50"	3.50"	3.44"	2.83"	1.89"	1/2 - 1 3/8"



ANSI Clutch Drive Tap Collets

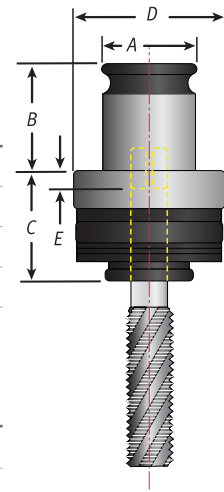


Note: Metric tap collets available on request. Please verify shank diameter when ordering metric tap collets.

ANSI Clutch Drive Tap Collet Features

- Prevents broken taps
- Automatically stops spinning when bottom is reached
- Change worn taps in seconds

Dimensions	A	B	C	D	E
Size 0	.51"	.77"	.83"	.91"	.24"
Size 1	.75"	.85"	.98"	1.26"	.31"
Size 2	1.22"	1.38"	1.34"	1.97"	.16"
Size 3	1.89"	2.19"	1.77"	2.83"	.04"



Collet Set

Part No.	Description
48/3-SET	Size 3, 16 piece set – 1/2" thru 1" NPT

ANSI Clutch Drive Tap Collets

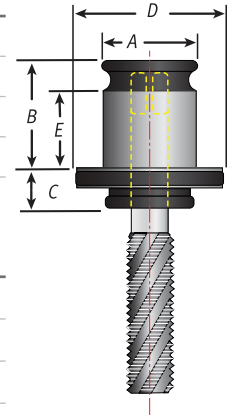
ANSI	Metric Tap / ANSI Shank	Shank	SQ	Size 0	Size 1	Size 2	Size 3
0-6"	M1.6-M3.5	0.141"	0.110"	13/0-4036	19/1-4036		
8, 5/32"	M4	0.168"	0.131"	13/0-4041	19/1-4041		
10, 3/16"	M4.5, M5	0.194"	0.152"	13/0-4048	19/1-4048		
12, 7/32"		0.220"	0.165"	13/0-4054	19/1-4054		
1/4"	M6, M6.3	0.255"	0.191"	13/0-4063	19/1-4063		
5/16"	M7, M8	0.318"	0.238"		19/1-4079	31/2-4079	
3/8"	M10	0.381"	0.286"		19/1-4095	31/2-4095	
7/16"	M11	0.323"	0.242"		19/1-4111	31/2-4111	
1/2"	M12, M12.5	0.367"	0.275"		19/1-4127	31/2-4127	48/3-4127
9/16"	M14	0.429"	0.322"		19/1-4142	31/2-4142	48/3-4142
5/8"	M16	0.480"	0.360"			31/2-4158	48/3-4158
11/16"	M18	0.542"	0.406"			31/2-4174	48/3-4174
3/4"		0.590"	0.442"			31/2-4190	48/3-4190
13/16"	M20	0.652"	0.489"			31/2-4206	48/3-4206
7/8"	M22	0.697"	0.523"			31/2-4222	48/3-4222
15/16"	M24	0.760"	0.570"				48/3-4238
1"	M25	0.800"	0.600"				48/3-4254
1 1/8, 1 1/16"	M27	0.896"	0.672"				48/3-4286
1 1/4, 1 3/16"	M30	1.021"	0.766"				48/3-4317
1 3/8, 1 5/16"	M33	1.108"	0.831"				48/3-4349
1/8" NPT		0.437"	0.328"		19/1 - 4097		
1/4" NPT		0.562"	0.421"			31/2-4131C	
3/8" NPT		0.700"	0.531"			31/2-4166C	48/3-4166C
1/2" NPT		0.687"	0.515"			31/2-4209C	48/3-4209C
3/4" NPT		0.906"	0.678"				48/3-4264C
1" NPT		1.125"	0.843"				48/3-4332C

ANSI Rigid Tap Collets



- Change worn taps in seconds
- Quick-Change Style

Dimensions	A	B	C	D	E
Size 1	.75"	.85"	.28"	1.18"	.39"
Size 2	1.22"	1.38"	.43"	1.81"	.75"
Size 3	1.89"	2.19"	.55"	2.68"	1.18"
Size 4	2.36"	2.48"	1.65"	3.27"	1.14"



Collet Sets

Part No.	Description
19/11-SET	Size 1, 11 piece set – 0-6" thru 9/16" & 1/8" NPT
31/12-SET	Size 2, 13 piece set – 5/16" thru 1/2" NPT
48/13-SET	Size 3, 16 piece set – 1/2" thru 1" NPT

ANSI Rigid Tap Collets

ANSI	Metric Tap / ANSI Shank	Shank	SQ	Size 1	Size 2	Size 3	Size 4
0-6"	M1.6-M3.5	0.141"	0.110"	19/11-4036			
8, 5/32"	M4	0.168"	0.131"	19/11-4041			
10, 3/16"	M4.5, M5	0.194"	0.152"	19/11-4048			
12, 7/32"		0.220"	0.165"	19/11-4054			
1/4"	M6, M6.3	0.255"	0.191"	19/11-4063			
5/16"	M7, M8	0.318"	0.238"	19/11-4079	31/12-4079		
3/8"	M10	0.381"	0.286"	19/11-4095	31/12-4095		
7/16"	M11	0.323"	0.242"	19/11-4111	31/12-4111		
1/2"	M12, M12.5	0.367"	0.275"	19/11-4127	31/12-4127	48/13-4127	
9/16"	M14	0.429"	0.322"	19/11-4142	31/12-4142	48/13-4142	
5/8"	M16	0.480"	0.360"		31/12-4158	48/13-4158	
11/16"	M18	0.542"	0.406"		31/12-4174	48/13-4174	
3/4"		0.590"	0.442"		31/12-4190C	48/13-4190	
13/16"	M20	0.652"	0.489"		31/12-4206C	48/13-4206	
7/8"	M22	0.697"	0.523"		31/12-4222C	48/13-4222	
15/16"	M24	0.760"	0.570"			48/13-4238	
1"	M25	0.800"	0.600"			48/13-4254	
1 1/8, 1 1/16"	M27	0.896"	0.672"			48/13-4286	
1 1/4, 1 3/16"	M30	1.021"	0.766"			48/13-4317	
1 3/8, 1 5/16"	M33	1.108"	0.831"			48/13-4349	
1 1/2, 1 7/16"	M36	1.233"	0.925"				60/14-4381C
1 5/8"	M39	1.305"	0.979"				60/14-4412C
1 3/4"	M42	1.430"	1.072"				60/14-4444C
1 7/8"		1.520"	1.139"				60/14-4476C
1/8" NPT		0.437"	0.328"	19/11-4097			
1/4" NPT		0.562"	0.421"		31/12-4131C		
3/8" NPT		0.700"	0.531"		31/12-4166C	48/13-4166C	
1/2" NPT		0.687"	0.515"		31/12-4209C	48/13-4209C	
3/4" NPT		0.906"	0.678"			48/13-4264C	
1" NPT		1.125"	0.843"			48/13-4332C	

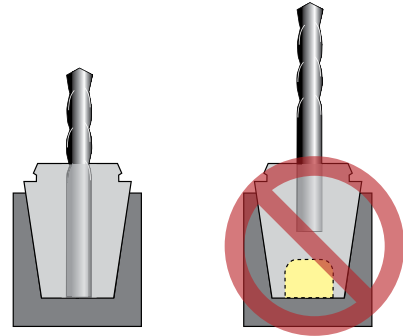


Tightening Torque Specifications Chart

Recommended Collet & Retention Knob Tightening Torque

Collet	Nut Type	Collets I.D. OVER 1/16" (2mm)	Collets I.D. UNDER 1/16" (2mm)	Order Torque Wrench Adapter
ER16	slotted	42 ft/lbs	30 ft/lbs	04580-16
ER16	hex	42 ft/lbs	30 ft/lbs	04601-16
ER20	slotted	59 ft/lbs	24 ft/lbs	04580-20
ER20	hex	59 ft/lbs	24 ft/lbs	04602-20
ER25	slotted	77 ft/lbs	77 ft/lbs	04503-25
ER25	mini nut	25 ft/lbs	25 ft/lbs	04587
ER32	slotted	100 ft/lbs	100 ft/lbs	04604-32
ER40	slotted	130 ft/lbs	130 ft/lbs	04605-40
SYOZ 25	hook	90 ft/lbs	90 ft/lbs	03690-25
TG 75	slotted	90 ft/lbs	90 ft/lbs	04604-32
TG 100	hook	90 ft/lbs	90 ft/lbs	03690-25

Retention Knobs	Wrench Flats	Drive	Torque	Order Socket
BT30 Taper	0.535"	1/4"	36 ft/lbs	PSS-30BT
ISO 30 Taper	0.535"	3/8"	36 ft/lbs	PSS-30ISO
Any 40 Taper	0.750"	3/8"	76 ft/lbs	PSS-40
BT50 Taper	1.187"	1/2"	99 ft/lbs	PSC-50
CAT50 Taper	1.250"	1/2"	99 ft/lbs	PSC-50



For maximum holding power fill the collet all the way with the tool shank (left) and use a PowerCOAT nut.

DIRECTIONS

1. Snap collet into nut.
2. Insert cutting tool into collet. Make sure shank extends to the bottom of the collet.
3. Hand tighten collet nut assembly into toolholder.
4. Insert toolholder assembly into tightening fixture and secure it.
5. Tighten collet nut to recommended torque using a torque wrench and adapter.